Work Orde <i>July-09-13</i> 11:42		4205		*104	4205*						Page 1
Revision ID:	546.9711 Blade	É	p. A.M	Accept	*N900	14 0	100)* s	etup Star Stop	I VI	S1* S2*
Start Date: Required Date: Reference:	7/09/13 7/09/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item II Customer:) :		4			
Approvals:	Process Pla	an: MLJ	Date: \\(\frac{1}{2} - 0 \) - \(\frac{7}{2}\)	Tooling: SPC (Y/N):	Da			R	Run Star Stoj	'' \	R1* R2*
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
646.9700	Α										
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut Blank a	t 4.625"	0.00	SA13-07-2	9		50	Ø		
*110 *110* HAAS I HAAS CNC vertical	machine #1	HAAS CNC VERTICAL Memo 1-Machine p DWG REV: FOLIO REV	per folio FB135 B	0.00	SA 13-08-01			50	Ø		لل

2- deburr and break all sharp edges except otherwise noted

DQA:			Date:											•	TOAC
						WORK ORDER NON	-CO	ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		•
	_	•				Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	No					Scrap		:	Machining	Small Fab	\exists	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	No	···				Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	1	Initial	Ac	tion		Sign &	<u>·</u>		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	1	QC Inspector
Design															
Doc/Data	Н	:													
Equip/Tooling	Н														
Handling/Pre	Н													:	
Material Operator	Н													ļ	
Offset/Setup	Н														
Process	Н													ļ	
Supplier	Н	: .													
Training	Н														
Transport															٠
Unapproved	П	#													
							FA	ULT CAT	TEGORY						
Landi	ng Ge	ear				General								_	
		Bending				Bend		Folio/F	rogram			Outside Dimi	ensions		Pressure/Forced
		entre No	t Concer	ntric		BOM/Route		Grain		Ī		Over/Under	tolerance		Set-up
	\square	Cracks				Broken/Damage/Defect		Hardwa	ire	[Part Incorrec	rt [Temperature/Cure
		rimp/Kin	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mis	ssing		Weld
	Щ	Cuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled
	-	rushing				Countersink		Misalig	ned/off center			Positioned W	/rong		
	\vdash	leat Trea				Cut Too Short		Mislabe	eled			Power Loss/S	Surge		Other
	-	nspection	•	Tube	_	Drawing	_	Misread	t		_				
	-	Marks/Ch			<u> </u>	Drill Holes		Off-set							
	\vdash	urning Se	-			Finish		1	Calibration						
	<u> </u>	Vave/Tw	ist in Tub	oe		Fit/Function		Out of 9	Sequence						

Work Ord July-09-13 11:4		04205		*104	4205	*							Page 2
Item ID: Revision ID: Item Name:	646.9711 Blade			Accept	*N¢	300	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date Reference:	7/09/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*			t Item I tomer:	D:		,				
Approvals:		Plan:	Date:	Tooling: SPC (Y/N):			ite:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description QC2- Inspect parts off m	achine FAI/FAIR	Set Up/ Run Hours	To	ool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*120 *120* QC Quality Control		Memo	aciniic i Ai/i Aib	0.00	S	13-09	1-01		50	£	<u> </u>		SLB-43
130 *130* QC Quality Control		QC8- Inspect parts - seco	and check	0.00	D .a	13 08	3 0Z		50		\$		0A.5 08 28
140		Outsource process - Heal	t Treat	0.00									

Outsource process - Heat Treat

HEAT TREAT AS PER DWG, SEE NOTE #3

ISSUE P/O: 209//

CX 13/08/13 (50)

140 Outsource1

Memo

0.00

DQA:		<u> </u>	Date:												
QA Closed:			Datas			WORK ORDER NON	-CO	ONFO	RMANCE / UF	PDATE		- 101		□ L A E R C	S P A C E
QA Closed.			Date:					<u> </u>			W	ork Order up	odate only		
Work Orde	er: '	1			i	DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	<u> </u>				_	Rework]		Skid-tube	Crosstube			Water Jet	Engineeri	ng
Part N	No.					Scrap	1	1	Machining	Small Fab	_	Pro	d. Eng. Coor.	Qual	- H
	-		7 411	1		Use-as-is	1	Thern	noforming	Finishing		4	re/Packaging	Oth	·
NCR N	No	:			_	Suspected Unapproved]		Large Fab	Composite			Supplier		
Root		. 1			Desci	ription of work order update		nitial	Acti	ion		Sign &			
Cause	1 0	ate	Step	Qty		or non-conformance	1	ief Eng	Descri			Date	Verification	QC Insp	ector
Design		,							3.33			Dute	Vermedion	QC IIISP	CCCOT
Doc/Data		·													
Equip/Tooling															
Handling/Pre															
Material	A														
Operator															
Offset/Setup															
Process							1								
Supplier							1								
Training							1								
Transport.							1								
Unapproved .															
			****				FA	ULT CAT	ΓEGORY						
Landir	ng Gear	•				General						_			
	Ber	nding				Bend	Ŀ	Folio/P	rogram	•		Outside Dim	ensions	Pressure/Fo	rced
	Cer	itre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up	
	Cra	cks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct [Temperatur	e/Cure
	Crir	mp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld	
	Cuf					Contamination		Instruct	ions Incomplete/U	nclear		Part Moved		Wrong Stock	Rulled
		shing				Countersink		Misalig	ned/off center			Positioned V	Vrong	_	
		at Treat				Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other	
			Strip in	Tube		Drawing		Misread	t						
	<u></u> Ма	rks/Ch	atter			Drill Holes		Off-set							
	\vdash		equence			Finish		Out of (Calibration						
	l lwa	ve/Twi	st in Tub	ne		Fit/Function		Out of S	Sonuence						

Work Ord		04205		*1(1420)5*					Managari Andrews		Page 3
Item ID: Revision ID: Item Name:	646.9711 Blade			Accept	*	1900	040	100)*	Setup	Start Stop	171	S1* S2*
Start Date: Required Date Reference:	7/09/13 : 7/09/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*			Cust Item I Customer:	D:						
Approvals:		Plan:	Date:	Tooling: SPC (Y/N):			ate:			Run	Start Stop	171	R1* R2*
Sequence ID/ Work Center I 150 *150* Packaging Packaging	ID	Operation Description Receive & Inspect for Dan	mage & Mat'l Certs	Set Up/ Run Hou 0.00	rs	Tool ID	Tool#	Plan Code	Accep Qty	ot Re Qt		Reject Number	Insp. Stamp
155 *155* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00	9- 23				50				
*160 *160* SprayPaint Spray Painting		Spray Painting per QSI00 Memo PRIME AS F	95 4.2 PER DWG, SEE NOTE #4	0.00					50	2	Ø	_ Ø	13-12-7

PRIMER BATCH: 127401

DQA:		· · · · · · · · · · · · · · · · · · ·	Date:			·							*	TQAR [®]
QA Closed:		!	Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	\٨/	ork Order up	ndate only		AEROSPACE
		i	Dute.			DISPOSITION			A C A INIC					,
Work Orde	er:					013P031110N 			AGAINS	ו טנ	PARTMENT,	/PROCESS		
						Rework			Skid-tube Crosstub	e 🗌		Water Jet		Engineering
Part N	۱٥					Scrap			Machining Small Fal	o[] Pro	d. Eng. Coor.		Quality
						Use-as-is		Therr	noforming Finishin	g	Rec/Sto	re/Packaging		Other
NCR N	No	- 1			_	Suspected Unapproved			Large Fab Composite	e]	Supplier		
Root		· ·	-		Descr	ription of work order update		nitial	Action		Sign &	<u> </u>	\neg	
Cause		Date	Step	Qty		or non-conformance	l	ief Eng			Date	Verification	n	QC Inspector
Design			•										\dashv	Qu'inspecto.
Doc/Data													į	
Equip/Tooling							ŀ							
Handling/Pre												:		
Material													-	
Operator		•												
Offset/Setup							l							
Process														
Supplier		:				•							ŀ	
Training														
Transport							i							
Unapproved							1							
							FA	ULT CA	TEGORY					
Landi	ng Ge	ar				General		_						
	В	ending				Bend		Folio/F	Program		Outside Dim	ensions		Pressure/Forced
		entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		racks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct [Temperature/Cure
		rimp/Kin	k/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing		Weld
	_	uffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved			Wrong Stock Pulled
	_	rushing				Countersink		Misalig	gned/off center		Positioned V	Vrong		
	Шн	eat Trea	t			Cut Too Short		Mislabe	eled	L	Power Loss/	Surge		Other
	_	-	Strip in	Tube		Drawing		Misread	t ·			<u> </u>		
	Ш∾	1arks/Ch	atter			Drill Holes		Off-set						
		urning Se				Finish		Out of (Calibration					
	Ιlν	Jave/Twi	ist in Tub	16	- 1	Fit/Function	_	Out of	Seguence					

Work Ord July-09-13 11:		4205		*104	1205*							Page 4
Item ID: Revision ID: Item Name:	646.9711 Blade			Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1* S2*
Start Date: Required Date Reference:	7/09/13 :: 7/09/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N *N	R1* R <i>2</i> *
Sequence ID/ Work Center 170 *170* QC Quality Control	ID	Operation Description QC14- Inspect Spray Pair Memo	nt	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty 50	Re Qt	•	Reject Number	Insp. Stamp <u>Mm/ 13</u> ·12·07
*180 *180* Packaging Packaging		Identify as per dwg & Sto	ick Location: <u>compos</u> ite (finishing)					50				MN 13-12-09
190 *1 QA* QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00					/	13/1	2/ca	0

DQA:		<u> </u>	Date:						_							
		:	Data			WORK ORDER NON-	-C(ONFO	RMANCE / U						AEROSPACE	
QA Closed:			Date:					1			Wo	rk Order up	date only			•
Work Orde	er:					DISPOSITION				AGAINST	DEP	ARTMENT	/PROCESS			
	_					Rework			Skid-tube	Crosstube			Water Jet		Engineering	
Part N	١o.	!				Scrap		!	Machining	Small Fab	7	Pro	d. Eng. Coor.		Quality	
	_					Use-as-is		Thern	noforming	Finishing			e/Packaging		Other	
NCR N	10					Suspected Unapproved			Large Fab	Composite			Supplier			
Root					Desci	ription of work order update		Initial	Act	tion	T	Sign &	·	T		į
Cause		Date	Step	Qty		or non-conformance	ı	ief Eng		ription		Date	Verification		QC Inspector	
Design										<u> </u>				\top		
Doc/Data		1														
Equip/Tooling														1		
Handling/Pre																
Material																
Operator																
Offset/Setup																
Process			:													
Supplier																
Training												•				
Transport																
Unapproved		,						_								
							FA	ULT CAT	regory							
Landir	ng Gea	r				General		_		_						
,	Be	nding				Bend		Folio/F	rogram			Outside Dim	ensions [F	Pressure/Forced	
	Ce	ntre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up	
	—	icks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct [1	Temperature/Cure	
	_		k/Ripple	/Wave		Burrs		Inspect	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	\	Weld	
	Cu					Contamination		Instruct	ions Incomplete/U	Jnclear	'	Part Moved		\	Wrong Stock Pulled	
		ushing				Countersink	L	1 -	ned/off center			Positioned W				
		at Trea				Cut Too Short		Mislabe	led	[Power Loss/S	Surge		Other	
		•	Strip in	Tube		Drawing		Misread	1		_	·=··				
	_	arks/Ch				Drill Holes		Off-set			_					
ļ	_	-	equence			Finish		Out of (Calibration		_					
Į.	l Ι _Μ ,	we/Twi	ist in Tub	10	- 1	Fit/Function	1	Out of s	Soguence		_					•

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Picklist Print

July-09-13 11:42:10 AM

Work Order ID:

104205

Parent Item:

646.9711

Parent Item Name:

Blade

Start Date: 7/09/13

Required Date: 7/09/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments.

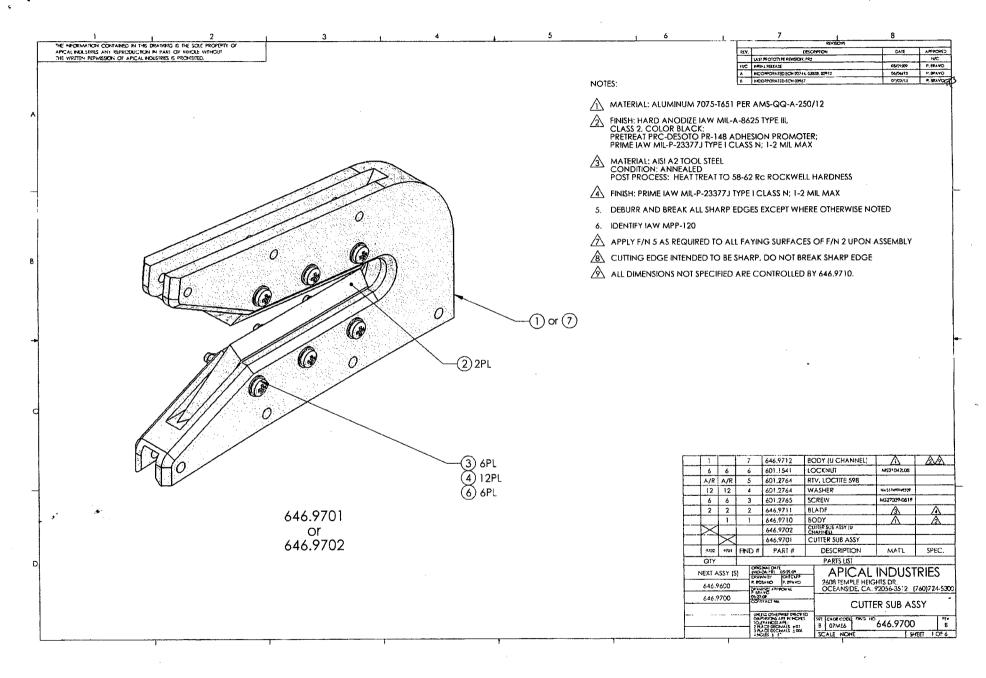
IPP REV-A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

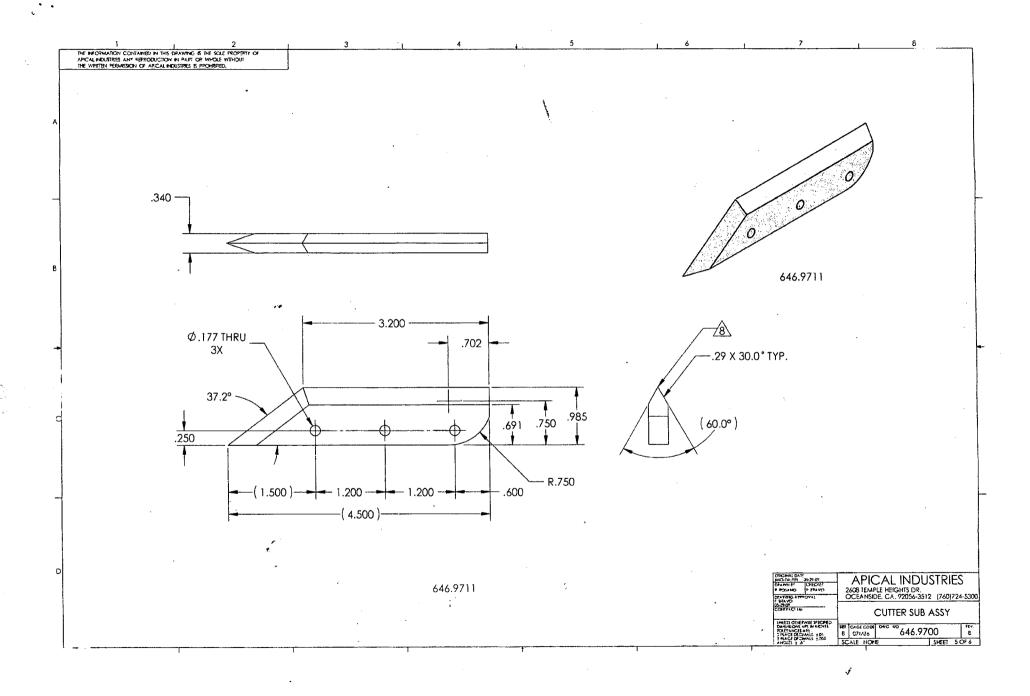
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250 AISI A2 TOOL STEEL BA	AR, 0.500 X 1.250	Purchased	No			100	f	107.4280	0.386 ZO	16.252632 .833'	J,	13-0	7-29
				Location		Loc Qty	Lo	c Code					
				MAT009		107.4280001							
				12	3250	0.0000001							
				12	5350	2.7576							
				M	126166	104.6704			<u> 20.</u>	<u>833'</u>			

DQA:			Date:			-							/3	
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UI		Moule Oudon		,	AEROSPACE
CA Closed.		!	Date.								Vork Order u	odate only		
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
	-				_	Rework			Skid-tube	Crosstube		Water Jet		Engineering
Part N	۷o.					Scrap		!	Machining	Small Fab	Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	۷o. ₋					Suspected Unapproved			Large Fab	Composite		Supplier		
Root	T				Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance		ief Eng		iption	Date	Verification	,	QC Inspector
Design	П		<u> </u>		ļ — —						1	vermoutio.	+	QC 1113pccco1
Doc/Data														
Equip/Tooling													İ	
Handling/Pre		•									·			
Material														
Operator										ŀ				
Offset/Setup														
Process														
Supplier														
Training														
Transport							ŀ							
Unapproved														
							FAI	ULT CAT	EGORY					
Landi	ng G	iear	-			General								
		Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pr	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Se	et-up
		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	ct		emperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspecti	on Incomplete/Un	qualified	Part Lost/Mi	issing		/eld
		Cuffs				Contamination		1	ions Incomplete/U	· -	Part Moved			rong Stock Pulled
		Crushing				Countersink		1	ned/off center		Positioned V	د Vrong		• •
		Heat Trea	t			Cut Too Short		Mislabe			Power Loss/	, ,	\neg o $^{\circ}$	ther
		Inspection	n Strip in	Tube		Drawing		Misread	I	l		~ [
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		ł	Calibration					
	Turning Sequence Finish Wave/Twist in Tube Fit/Function							1	Sequence					

	1							
		ENGINE	ERING CHANGE	NETTER NO	. 03912			SHEET 1 L
A	PICAL	DWG NE]. 646.9700	REV: N/(PREPARED J.	BECKER	DATE: 06/	06/13 EFFECT D.
	DUSTRIES, INC.	DWG TI		SUB ASSY				/
····		APPROVED B		~ MFG L	Jarry Borbar SHEET 6. IN	QC QC	44-1	effi NEXT ORDER
AA	SACTION CODES (TC): DD C-CREATE PEVISE D-DELETE	REASON	H ADDED NOTE ECN'S 02744		> · · · · · · · · · · · · · · · · · · ·	CORPOR	ATED /	
								104205 MC5 13-07-12
7 C		1		BODY (U CHAN	INEL)			A A
		1 \ / 1	June 1 to the same but		1 200 4 4 4 4 1 4 1 200 4 4			ì

<u> </u>		0 (0,0)12							7	/2\/9\
	С	646.9702	\bowtie		CUTTER SUB ASS	Y (U CHAI	NNEL)			
F/N	тс	PART NUMBER	.9702 QTY	.9701	DESCRIP	TION		MATER	RIAL	SPECIFICATION
DO	CUME	NTS EFFECTED:			☐ INSTALL INSTRUC	□ ICA	⊠ BOM □ MAJOR	CATEGORY MINOR	DER RE	VIEW REQUIRED ES 🛛 NO





DART AEROSPACE LTD	Work Order:	
Description: Blade	Part Number:	646.9711
Inspection Dwg: 646.9700 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing		Actual	1	<u> </u>	Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
0.340	+0.000/-0.005	-340			vern	JL-10
Ø0.177	+0.005/-0.001	1115	1		-	
3.200	+/-0.005	3,200				
-0.500-	-+/ -0.005		/_			
0.985	+/-0.005	.987	/		-	
4.500	+/-0.005	4,495			~	
2.400	+/-0.005	2.400	//		~	
1.200	+/-0.005	-200			-	
1.500	+/-0.005	1.497			~	
0.250	+/-0.005	-250		-	~	
37.2°	0.5°	37,2				
. 0.29 x 30°	+/-0.010 x 0.5°	293x30°			_	
	·	-				
,						

Measured by:	12	Audited by:	D.O OAS	Preliminary Approval:	
Date:	13-7-30	Date:	13/08/02 20	Date:	

Rev	Date Change		Revised by	Approved
Α	13.06.03	New Issue	KJ	
В	13.06.27	Dwg Rev updated	KJ in	
C	13.07.18	Dwg Rev updated	KJ 😽	Chill
	1		7	7/

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ ST-EUSTACHE, QC J7R 5A8 Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL	EXPÉDITEUR	BON D'EXPÉDITION
Order	Shipper ID	Shipper
188538	1	73982

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer

215

DART AEROSPACE 1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

Ph: 613-632-5200 Fax: 613-632-1053 LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

Ph: 613-632-5200 Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
PO20911		A2	2013/8/14	FEDEX
QUANTITÉ No. PIÈCE Quantity Part No.	E LA PIÈCE on	POIDS Weight		
MATERIA 58-62 RC	NCE 104205 N.: AISI A2 TOOL STEEL		Q13-8	14,
TYPE DE CONTENEUR	# DE CONTENEURS		RES CONTENEUR	
Container Type BOITE DE CARTON	# Of Containers	Container Com	iments	
CERTIFICAT				
		QUANTITÉ EXPÉDI	ÉE / Quantity Shipped :	50
EMPAQUETAGE Packing		POIDS EXPÉ	DIÉ / Weight Shipped :	14,00
339		QUANTITÉ RESTANTE	E / Quantity Remaining :	(
		POIDS RESTAN	NT / Weight Remaining :	0,00

Date:

EXPÉDIÉ LE / Shipped On: 2013/08/16

POIDS EXPÉDIÉ / Weight Shipped :

14,00

F-050-06 Rev. B

Signature:



560, boul. Arthur-Sauvé, St-Eustache (Québec) J7R 5A8 Tél. 450 473-1884 Télécopieur/Fax administration 450 491-5498 Télécopieur/Fax production 450 491-6454

Rapport d'Inspection

Inspection Report

BON DE TRAVAIL order	CHARGEMENT load
188538	1

CLIENT / customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to: DART AEROSPACE 1270 ABERDEEN HAWKESBURY

ON KBA 1K7

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CUENT	MATÉRIEL	CODE DE TRAITEMENT	NUMÉRO DE LOT
	customer shipper no.	material	mat'l heat code	lot number
PO20911		A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement | SPÉCIFICATIONS / specifiedTESTS EXÉCUTÉS / performed | RÉSULTATS DE TESTS / results | HARDNESS | 58 - 62 HRC | 5 | 60.0 - 61.0 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
50	14	848.9711 (50) BLADE REFERENCE 104205 MATERIAL: AISI A2 TOOL STEEL 58-62 RC
		CONTENANT: 1 BOÎTE DE CARTON

COMMENTAIRES / comments

CERTIFIÉ par / Certified by: METCOH DATE: 2013-08-16

METCOR INC. 560 BOUL. ARTHUR-SAUVÉ ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL	CHARGEMENT
order	load
188538	1

CLIENT / customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to: DART AEROSPACE 1270 ABERDEEN HAWKESBURY

ON K6A 1K7

COMMAN	DF C	OU CLIE	NT BON	I DE LIVRAISON D	OU CLIENT	MATÉF	RIEL (CODE DE T	RAITEMENT	NUMÉRO	DE LOT
				customer shippe	er no.	mater		mat'l he	at code	lot nu	mber
P	0209)11	1 A2								
			 	SF	PÉCIFICA	TIONS DU	PROCÉD)É	***************************************		
					proces	sing specifi	cations				
VAC HARD	EN							•			
HARDEN A											
EXIGENCE	/ rec	uireme		IFICATIONS	/ specified	TESTS EX		performed	RÉSULTA	TS DE TES	TS / results
HARDNES	SS		58 - 6	2 HRC			5		60.0 - 61.0	HRC	
QUANTITI quantity	É			DESCRIPTIO		ÈCES					
7	50		~	646.9711							
				(50) BLADE	T 40400E						
				REFERENCE MATERIAL:		OOL STEEL					!
				58-62 RC							
				CONTENAN	T: 1 BOÎT	E DE CART	ON				
Operation	Temp. Speci	spécifiée fied Temp	Temps de trem Spécifié Specified Soa Temp	7 11	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1.00 CONT. INIT.	LA	VAGE		si nécessaire							
	201/	IPTAGE		<u> </u>					<u> </u>		
PREPARING			=								
3.00	1	200	0:30	VAC			390				
PREHEAT 1											
4.00	1	500	00 0:30 VAC								
PREHEAT 2											
5.00 VAC HARDE	ı	800	1:00 VAC AZOTE								
		+/-10°F	F 2 hrs air 651								
7.00 TEMPER 2	400	+/-10°F	2 hrs	air			651				

METCOR INC. 560 BOUL. ARTHUR-SAUVÉ ST-EUSTACHE, OC, J7R 5A8

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order	load
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1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to: DART AEROSPACE 1270 ABERDEEN HAWKESBURY

ON K6A 1K7

Operation	I Specified James	Temps de trempe Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four #		Heure d'entrée Time In	Date Complétée Date complete
8.00 HARDN INS	l i					·			
9.00 FINAL INSP	l i						08-16-2013		08-16-2013

COMMENTAIRES / comments

Le traitement thermique a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de traitement thermique ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandées ont été faites et documentés.

Aucun changement ou dérogation n'a été faite par rapport au traitement thermique demandé.

On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiés.

All the heat treatment processing performed on this order was accomplished using heat treatment equipment compliant with the requested heat treatment specification.

All the heat treatment operations were accomplished in accordance with the requested/required heat treatment specification and all required verifications test have been performed and documented.

No unauthorized changes or deviations to required heat treatment specifications or procedures have been performed. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

APPROUVÉ par / Approved by:	DATE: 2013-08-20
L	
	(ME)

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client./We certify that all the information on this report is exact and in accordance with the order requirements.



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20911

Purchase Order Date 8/13/2013 PO Print Date 8/13/2013

Page Number 1 of 1

Order From:

METCOR INC.

560 BOUL. ARTHUR SAUVE SAINT-EUSTACHE, QC J7R 5A8 VC-MET004

Ship To: DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

F®SomD

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone Ship Via:

Ship Acct:

450 473 1884

FedEx PI collect

Buyer

Chantal Lavoie

Customer POID
Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Reference
Nor Vendor Part Number
Line Comments
Delivery Comments

Description/ Mfg ID Req Date/ CD Taxable Req Qty/ Unit of Measure ____

PO Unit Price Extende

646.9711 blade

8/23/2013

Promise Date

Yes 8/23/2013 50.00

\$4.32

\$216.0

Pri

PART ARE MADE FROM: AISI A2 TOOL STEEL

FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS

13-8-33 Line Total:

\$216.0

2 104205

DETAIL C OF C

8/23/2013

1.00

\$48.00

\$48.0

8/23/2013

Yes

Line Total:

\$48.0

PO Total:

\$264.1

CX

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required TES

PST# 6122-5207

1

Change Nbr:

Change Date:

8/13/2013

ES NO